

Date: Thursday, 27/11/2008 2:23:59 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PLUG
<b>Job Number</b> : 43816	
<b>Estimate Number</b> : 12322	
<b>P.O. Number</b> :	<b>Part Number</b> : D3492041
<b>This Issue</b> : 27/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3492 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 42936	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 08/12/2008 <b>Qty:</b> 200 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08.11.27</u>	
<b>Comment</b> : : est rev A 06.03.03 New Issue EC Est Rev:B 06-08-28 As per Rev B JLM Est Rev:C 07-12-06 Rev C dwg DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M6061T6R0625	6061-T6 Round Bar .625"
-----	--------------	-------------------------



**Comment:** Qty.: 0.0656 f(s)/Unit Total : 13.1250 f(s)  
 6061-T6 Round Bar .625"  
 (M6061T6R0625)  
 Batch: M109733 08/11/30

200 pcs

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------

**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA633 &amp; Dwg D3492

Dwg Rev: CFolio Rev: B08/11/30

200 pcs

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

08/11/30**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

200 pcs

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK31 08/11/30

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary

N/A Solidig

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 27/11/2008 2:24:00 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 43816

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Tumble

B 8-12-19

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

8 08/12/19 (200)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(200)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/12/22

8.0

POWDER COATING

POWDER COATING



M104a96



(200X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00  
320 OF  
11:30

M-1 08/12/30

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(200)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/12/30

10.0

PACKAGING 1

PACKAGING RESOURCE #1



(200X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-B

M-1 08/12/30

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(200)

Comment: FINAL INSPECTION/W/O RELEASE

2009/01/05

Job Completion



MF 08-12-31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

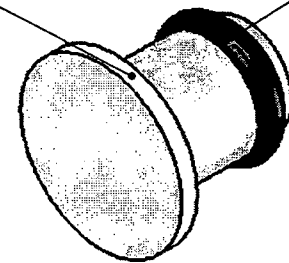
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING



#### NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

~~UNDER REVIEW~~

03.07.21.08

OK ASS 08.11.12

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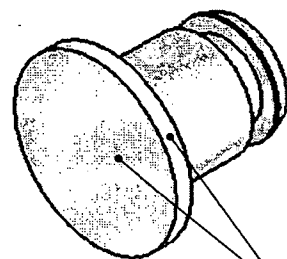
WITHOUT NOTICE

WORK ORDER

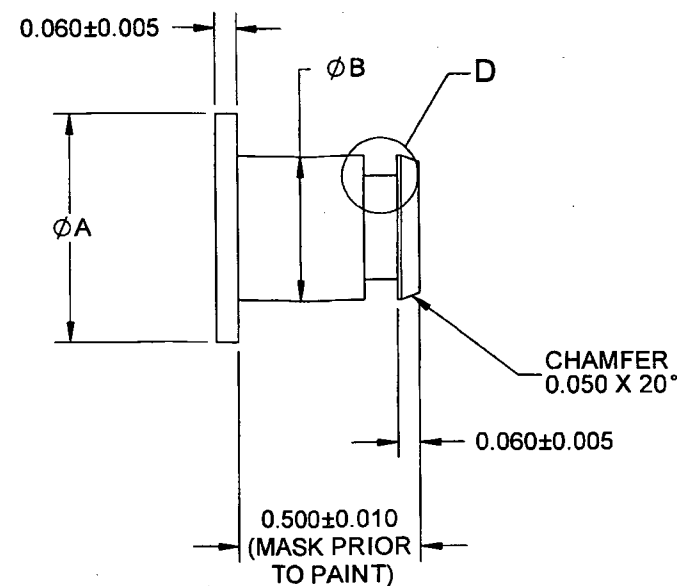
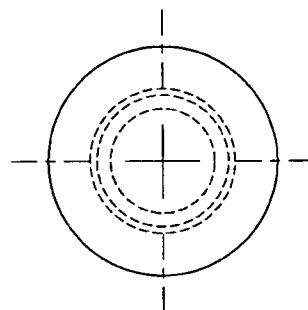
4326

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3492	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	2:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

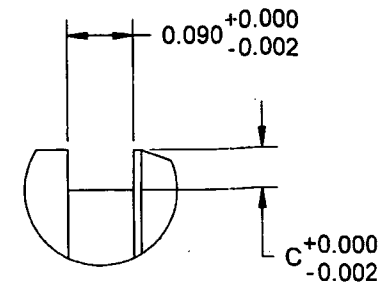




POWDER COAT THESE  
FACES ONLY PER NOTE 2



**D3492-XX PLUG**



**DETAIL D**

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

**UNDER REVIEW**

08.07.11 RBA

DIM B ON D3492-3  
REF. CK (HIRE SHILLER)

ASS 08.11.12

OKay

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WORK ORDER  
NO. 43816

**DEO ATTACHED**

DESIGN	RH	<b>DART AEROSPACE LTD</b>	
DRAWN	RH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	7	DRAWING NO.	REV. C
MFG. APPR.	7	D3492	SHEET 2 OF 2
APPROVED	7	TITLE	SCALE
DE APPR.	7	PLUG	4:1
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DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SC NTS
DRAWN AJS	CHECKED	MFG. APPR. <i>B</i>	APPROVED <i>W</i>	DE APPR. <i>H</i>			
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05	DATE 08/11/05			

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

WAS:

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

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